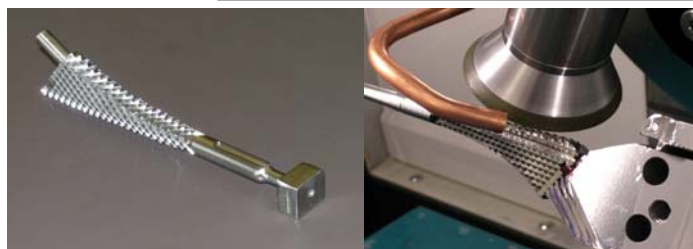
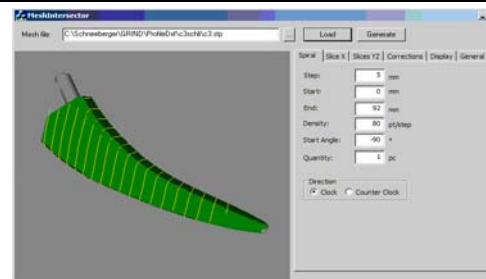







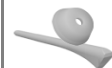
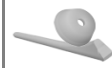
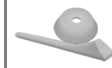








Hip Rasp diamond shaped Teeth

A26-200

Based on a given 3D-model the grinding paths can be generated along predefinable textures (spirals, oblique lines) on the surface. Within our softwarepackage Meshintersector Spiralangle and lineangles and repetition of the texture are free definable. Each part of the 3D surface to be executed is attached to an operation. The teeth depth are considered based on the surface curvature. The teeth all around the tool are ground in one setup.



1. Cycletime for Production

Tool specifications								
LxHxB 125x35x20								
Material Medical Steels								
Operations								
	Pregr. Side 1	Fin. Side 1	Pregr. Side 2	Fin. Side 2	Pregr. Top	Fin. Top	Pregr. Bottom	Fin. Bottom
Feed [mm/Min]	250	500	250	500	250	500	250	500
Power [kW]	1	1	1	1	1	1	1	1
Cutting feed [m/s]	30	30	30	30	30	30	30	30
Used wheels								
Grinding time [s]	917	533	917	533	917	533	917	533
Total cycle time	96 Min 40							

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

13 Ø75 1V1 60° B126
12 Ø75 1V1 60° B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, NORMA CFG, Special Clampings
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: OP,10.1.08

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China